

Work Order ID 160966

Friday, May 05, 2017 11:14:05 AM

160966

Page 1

Item ID: D4151-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lower Hardpoint Plate
Start Date: 5/9/2017 Start Qty: 60.00 ***60*** Cust Item ID:
Required Date: 5/11/2017 Req'd Qty: 60.00 ***60*** Customer:
Reference: (P.A.)SCHEDULED/S MAY 05 2017
Approvals: Process Plan: PA **DAS 21 9-89** Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4151	C
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100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg D4151

Prog Rev: EDwg Rev: E

Deburr as required

2.89

SC 17/05/11

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.60

DAS 38 9-89SC 17/05/11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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160966

Page 2

Item ID: D4151-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lower Hardpoint Plate
Start Date: 5/9/2017 Start Qty: 60.00 ***60*** Cust Item ID:
Required Date: 5/11/2017 Req'd Qty: 60.00 ***60*** Customer:
Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 1.20				<u>66</u>			DAS 9 9-89 MAY 19 2017
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>087</u> Memo	0.00 0.60				<u>66</u>			DAS 6 9-89 MAY 23 2017
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 6.00							175/234 DAS 21 9-89 MAY 23 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

Friday, May 05, 2017 11:14:05 AM

Page 1

Work Order ID: 160966

160966

Parent Item: D4151-1

D4151-1

Parent Item Name: Lower Hardpoint Plate

Start Date: 5/9/2017

Required Date: 5/11/2017

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
11.01.21 as per dwg revC DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	48.9830	0.0508	3.208421			
M304S11GA									**			SC 17/05/11	
304/316 0.125 Sheet													

Location

Loc Qty

Loc Code

MAT020

48.983

M137110

26.2

M137263

22.783

33

DQA: _____ Date: _____

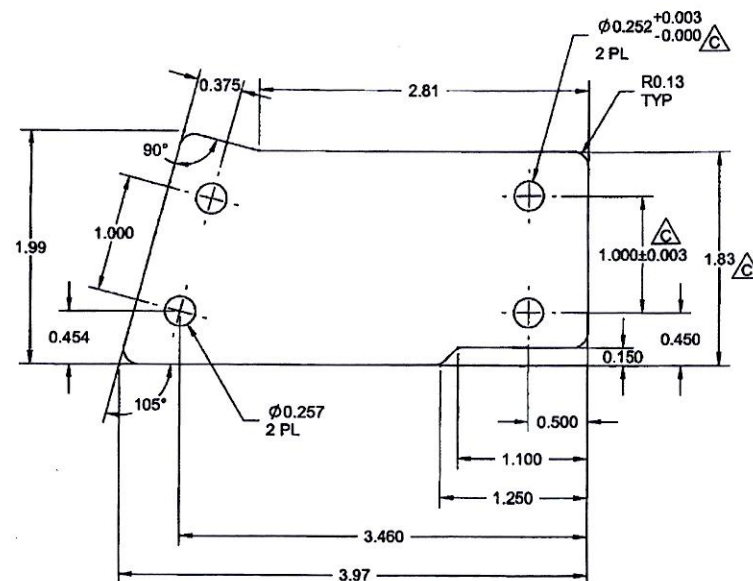
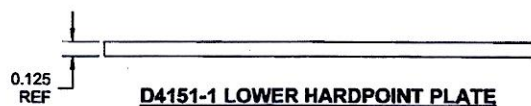


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Misidentified ☐	Past Due ☐																																																																



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160210

RELEASED
2011-01-18
MD

1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

7) WEIGHT:

- D4151-1 = 0.24 lbs

- D4151-1 = 0.24 lbs
- D4151-3 = 0.23 lbs

DESIGN			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			DRAWING NO.	REV. 0
CHECKED	SC		D4151	SHEET 2 OF 2
MFG. APPR.			TITLE	SCALE
APPROVED	AM		BASKET FWD HARDPOINT	NTS
DE APPR.			COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINTED ON RECYCLED PAPER. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	
DATE	10.12.14			

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																																																																

160280
160966 PA
D4151-1
2017/05/0

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by:	<i>Sc/ [Signature]</i>	Audited by:	<i>[Signature]</i>	Preliminary Approval:	
Date:	<i>17/05/17</i>	Date:	<i>MAY 19 2017</i>	Date:	

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	11.01.28	Dimensions updated per Dwg Rev C	KJ	

DQA: _____ Date: _____



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